
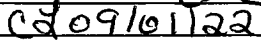


Date: Thursday, 22/01/2009 8:19:40 AM  
 User: Chantal Lavoie

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	GAS SPRING ASSEMBLY
<b>Job Number</b> :	45058		
<b>Estimate Number</b> :	10181		
<b>P.O. Number</b> :		<b>Part Number</b> :	D2153
<b>This Issue</b> :	22/01/2009	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2153 REV. A1
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	41421	<b>Drawing Revision</b> :	A1
	<b>Type</b> :	<b>Material</b> :	
	ESTIMATED PURCHASED PARTS	<b>Due Date</b> :	29/01/2009
<b>Written By</b> :		<b>Qty:</b>	36 Um: Each
<b>Checked &amp; Approved By</b> :			
<b>Comment</b> :	Est: E 02.07.08 Re-format KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



## Comment: PURCHASING

Issue P/O: 8028  
 Gas Spring P/N: SL13-10 (10lb)  
 Possible supplier: Spring Lift Corporation  
 \*\*Note: Do not ship by air\*\*\*\*  
 Allow an extra 7 to 10 business days for shipping\*\*  
 Material release note is required

C209101122

(36)

2.0	D2153P	Door Prop
-----	--------	-----------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 30.0000 Each(s)  
 GAS SPRING ASSEMBLY

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



## Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage  
 Ensure Material Release Note is attached

C209101122 (36)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK  
 Inspect Test Spring is 10lb

C209102105 (36) counter

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 22/01/2009 8:19:40 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING ASSEMBLY

Job Number: 45058

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D30153

Locknut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Lock Nut

Pick:

Qty Part Number

Description

Batch

2 D3015-3

Lock nut

43758

69X

44328

3X

✓

6.0

AN960JD516

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Washer

Pick:

Qty Part Number

Description

Batch

2 AN960JD516

Washer

110363

7.0

SL69BS

Ball Stud



Comment: Qty.: 2.0000 Each(s)/Unit Total : 60.0000 Each(s)

Ball Stud

Pick:

Qty Part Number

Description

Batch

2 SL69-BS

Stud

109239

✓ 9/2/09 (36)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2153

2- Remove Spring Lift name and address with Acetone, leave only warning:

"DO NOT OPEN HIGH PRESSURE"

✓ 09/02/09 (36)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

✓ 09/02/09 (36) counter

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST272

overstocked

✓ 09/02/09 (36)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 22/01/2009 8:19:40 AM  
User: Chantal Lavoie

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GAS SPRING ASSEMBLY

Job Number: 45058

Part Number: D2153

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

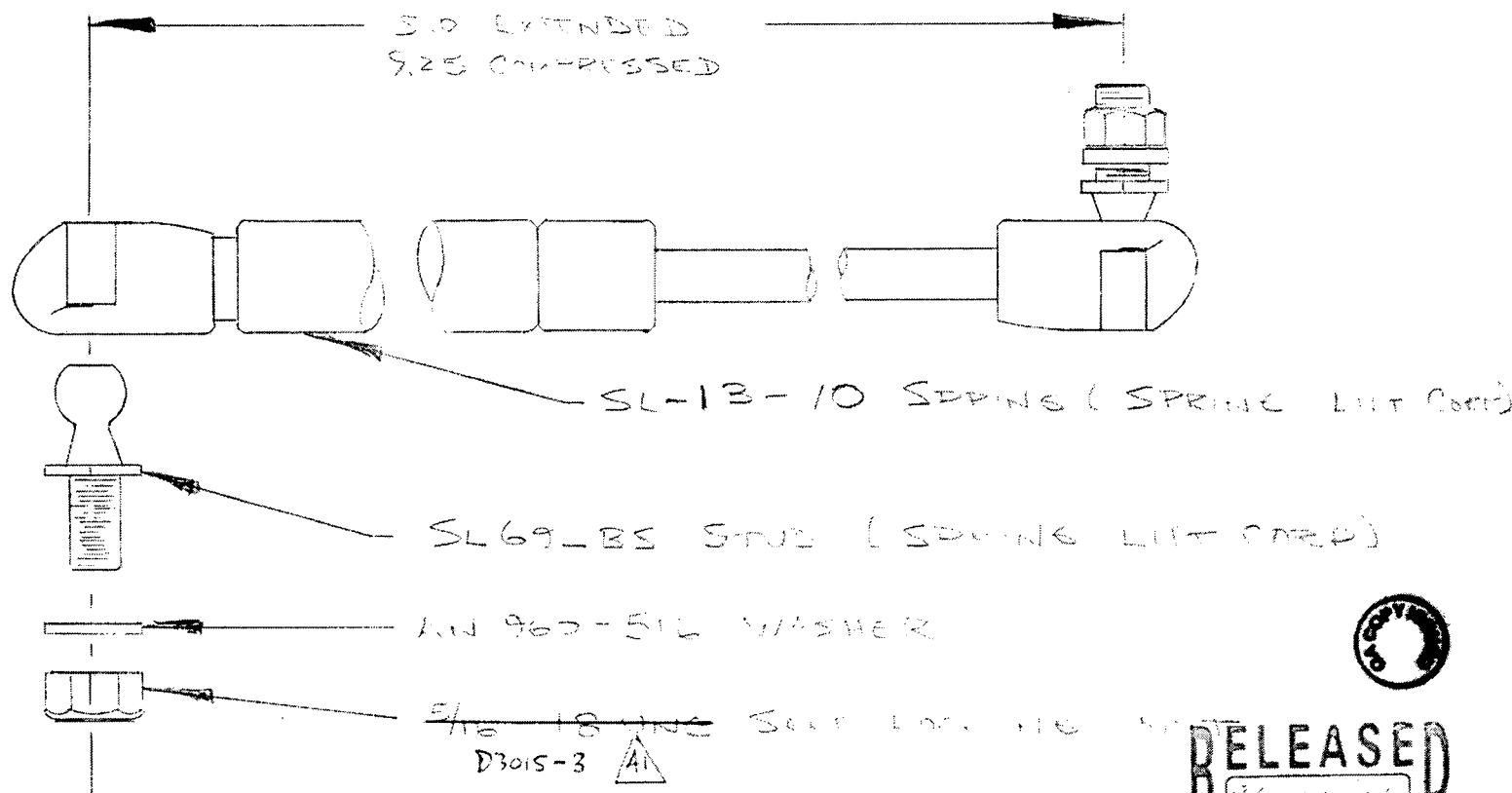
09/02/10 HJ

Job Completion



NF 09-02-09

W/O: 45058  
C809101122



RELEASED  
96-0416

A1		REVISION	RIVET CODE SHALL BE PER NAS 523		PART NO	ITEM	DESCRIPTION	MATERIAL	SPEC. VENDOR
1		DRAWN	BASIC CODE		CONTRACT NO		<b>DART</b> DART AERO ACCESSORIES INC. VANCOUVER CANADA		
1		APPROVED	D=DRAWN DUTY-HO OF SHEETS C=COUNTERSINK		DATE 02/22/77		TITLE GAS SPRING ASSEMBLY		
DESCRIPTION OF CHANGE 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH - 5 - 1142 5. HOLES PER AND 10387			LIMITS 1. TOLERANCES - .004 .030 2. ANGLES 1 1/2 3. PARALLELISM .0025 4. ECCENTRICITY .0025 MAX 5. SYMMETRY ABOUT ALL M/C CENTRAL LINES .005		BASIC CODES B2-M520470AD B8-M520476AD		CHECKED 02/22/77		CODE DZ153
REPORT ALL DISCREPANCIES - DO NOT SCALE					CLIENT 02/22/77		SCALE 1:1		REV A

DZ153

**airway**

**SWIVLE**

TELEPHONE: 616-897-2290

CUST: 68580 MGT: 26924-00

COLLECT 151793240

TO: DART AERO LTD.  
08A.01/23/09

PRO NO: 442 35111  
SHIP VIA: UPS GROUND  
BOL: 00226970001366671

FROM: SWIVL-EZE

FREIGHT:

1016 NORTH MONROE

MI -493 1-0260

DART AERO LTD.  
100 ABERDEEN STREET

MARKESURY

ON

K4 1K7

QRTS: 2 PO#: 8028

WGT: 15 DATE: 01/26/09

SPUR: 9

LABEL NO:  
4849660338

*Scholar*

ROUTING GUIDE INFO --

QTY	LOCATN	QM	PART#	UPC	DESCRIPTION	SRU	LINE	QTY	MGT
24	209211	EA	SL13-10-1		GS SPRNG 15" EXTC 10W BL		1	36	12
100	Z10321	EA	SL69-B5-1		10MM BALL STUD W/THRD		2	100	3

COMPLETE =====

PICK BY:

PAGE: 1

(ONLY PAGE)

**Purchase Order**

Date Jan 22, 2009	Page 1
Purchase Order Number PO00008028	

Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7  
Phone: (613)632-9577  
Fax: (613)632-1053

**Vendor Address:**

Attwood  
1016 North Monroe St  
Lowell, MI 49331  
USA  
Phone (616) 897-2370  
Fax (616) 897-8358

**Ship To:**

Main Finished Goods Location  
Dart Aerospace Ltd  
1270 Aberdeen St  
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VU-ATT001	Jan 22, 2009	N30	Fedex	Jan 30, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
36.0000	D2153P	Door Prop . Comments: AS PER DWG D2153 REV. A1 P/N: SL 3-10 (10LBS) GAS SPRING	30/01/2009	No	4.110000	Each	147.96
100.0000	SL69BS	Ball Stud	30/01/2009	No	0.800000	Each	80.00

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

Comments:	Tax Summary:		Less:	
			included tax	0.00
			Subtotal	227.96
	Entered By: CLAVOIE		Total tax	0.00
	Approved By:		Total purchase order in USD Dollars	227.96